

## Abstract

A method for the manufacture of components composed of difficult-to-cut materials for gas turbines, in particular for manufacturing integrally bladed rotors for gas turbine aircraft engines, by producing recesses with one or more side walls, the recesses forming flow channels and the side walls forming blade surfaces, whereby material in the region of the flow channels is removed by a drilling process, and after the drilling process is finished the remaining material in the region of said flow channels is removed by a milling process. The unique combination of a drilling process followed by a milling process completing the material removal reduces significantly the manufacturing time.